

Work Order ID 163425

Tuesday, June 27, 2017 12:09:36 PM

163425

Page 1

Item ID: D4918-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Center Aft

Start Date: 7/6/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUL 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4918

B

100

0.05

100

FLOW WATER JET

Waterjet

Memo

0.58

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

④ SC 17/07/04 DAS
19
9-89

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.04

Quality Control

④ SC 17/07/04 DAS
19
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Page 2

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Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Wearplate Center Aft

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4

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.08

Quality Control

4

DAS
38
9-89

JUL 04 2017

130

NC BRAKE

0.30

130

Brake NC

Memo

0.50

Brake NC

1-Form on brake using DT8326 and DT8261 as per Dwg
2-Form joggle as per Dwg Using DT8158

4

Ø

JUL 10 2017

DAS
19
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.08

Quality Control

4

DAS
38
9-89

JUL 10 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
2A0 0C 00-0 3A0 0T 00-0								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Page 3

Item ID: D4918-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center Aft
 Start Date: 7/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/14/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* SprayPaint Spray Painting	Memo APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 8 ON DWG) BATCH: <u>137803</u>	0.00 0.80				<u>4</u>			<u>DL</u> 17-07-12 DAS 41 9-89
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				<u>4</u>			DAS 38 9-89 JUL 13 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-002</u> Memo LOCATION : FP002	0.00 0.04				<u>X 4</u>	<u>4</u>	<u>12/02/13</u>	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Page 4

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.40

Quality Control

JUL 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, June 27, 2017 12:09:34 PM

Page 1

Work Order ID: 163425

163425

Parent Item: D4918-5

D4918-5

Parent Item Name: Wearplate Center Aft

Start Date: 7/6/2017

Required Date: 7/14/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.12.09 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	114.2600	0.66	2.778947			

M304S20GA

304/316 .040 Sheet

**

Sc 17/07/04

Location

Loc Qty

Loc Code

MAT020

114.26

m136327

3.15

m136568

3.78

m137263

2.5

m137362

5.73

m137513

35.1

m137762

64

2.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

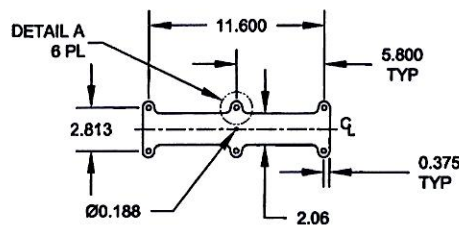
QA Closed: _____ Date: _____

Work Order update only ☐

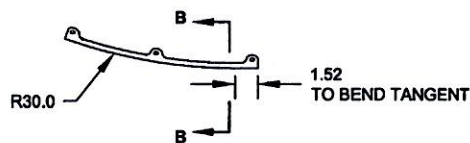
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		DAS 03	Work Order:	163425
Description: Wearplate		9-89	Part Number:	D4918-5
Inspection Dwg: D4918		Rev: A-B 17-7-3		Page 1 of 1

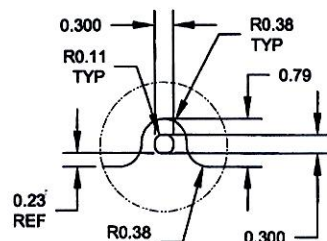
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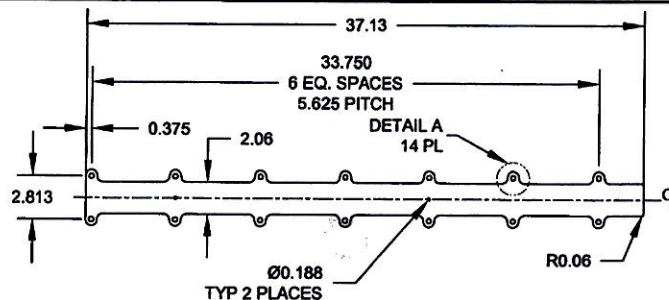
D4918-1F WEARPLATE
FLAT PATTERN



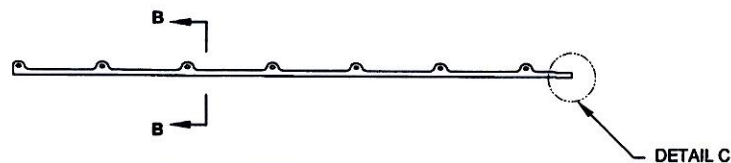
D4918-1 BENDING DETAIL
MAKE FROM D4918-1F



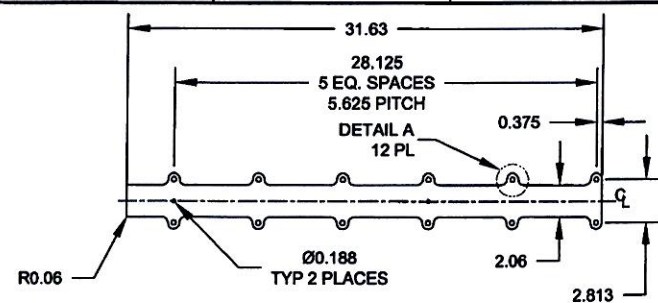
DETAIL A
SCALE 2X



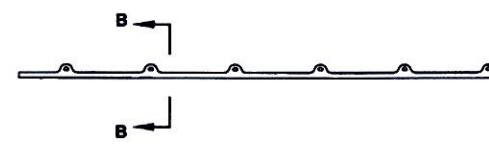
D4918-3F WEARPLATE
FLAT PATTERN



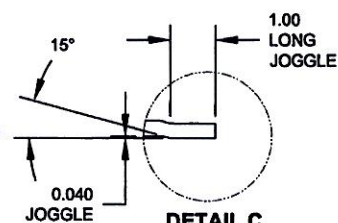
D4918-3 BENDING DETAIL
MAKE FROM D4918-3F



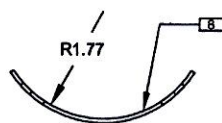
D4918-5F WEARPLATE
FLAT PATTERN



D4918-5 BENDING DETAIL
MAKE FROM D4918-5F



DETAIL C
SCALE 3X



SECTION B-B
SCALE 2X

NOTES:

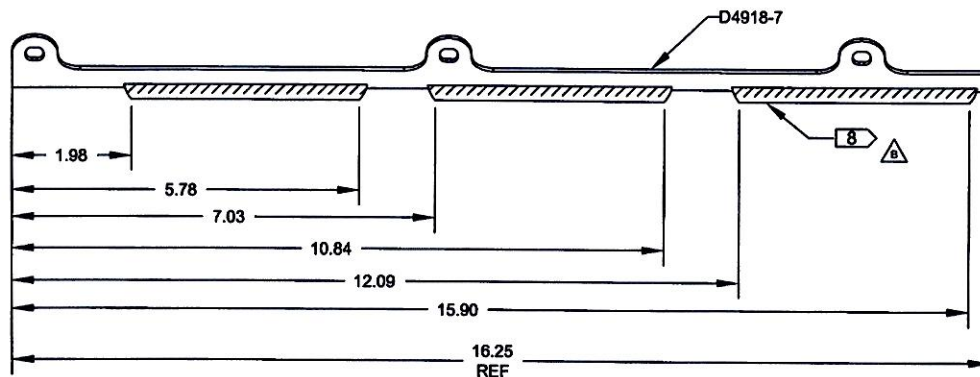
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED PER MIL-S-5059 OR AMS 5513 OR AMS 5524, OR ASTM A240 OR ASME SA240 20 GAUGE (0.038 THICK)
REF. DART MATERIAL SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N PER QSI 044 6.1
- 7) WEIGHT: D4918-1 - 0.47 LBS, D4918-3 - 0.95 LBS, D4918-5 - 0.77 LBS,
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
163425 MS
170703

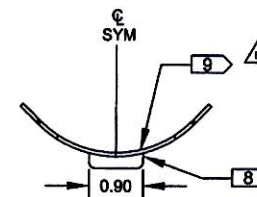
RELEASED
2017-04-12
ECN 17-554

B	CHANGE NOTE OF SURFACE COATING FROM ROCKGUARD TO TEXTURED COATING, WELDING NOTES UPDATED, REVISE DRAWING TO CURRENT STANDARDS, ADDED NOTCHES TO ENDS OF D4918-7F	SAD	17.02.14
A	NEW ISSUE	DW	13.08.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	SAD	EUGENE, OR	
CHECKED	MJ	DRAWING NO.	REV. B
MFG. APPR.	MJ	D4918	SHEET 1 OF 3
APPROVED	MJ	TITLE	SCALE
DE APPR.	MJ	WEARPLATE	NTS
DATE	17.02.14	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -047	P/N	DESCRIPTION
	X	D4918-047	WEARPLATE
1	1	D4918-7	WEARPLATE
2	A/R	8259 OR 2059B	HARDCOAT (AUTOMATED) HARDCOAT (MANUAL)



D4918-047 WEARPLATE
MAKE FROM D4918-7



NOTES:

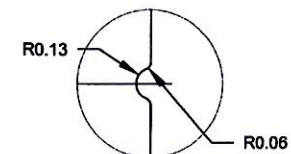
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4918-047" PER QSI 044 6.1
- 7) WEIGHT: 2.18 lbs
- 8) APPLY 2 LAYERS OF HARD SURFACING WELD BEAD 0.19 TO 0.25 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY 2 LAYERS OF HARD SURFACING WELD BEAD 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK PER QSI 005 4.9

RELEASED
2017-04-12

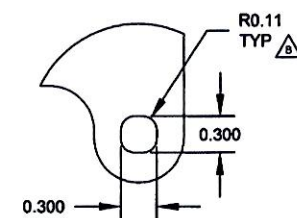
DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	SAD	EUGENE, OR	
CHECKED	<i>MKE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>M</i>	D4918	SHEET 2 OF 3
APPROVED	<i>M</i>	TITLE	SCALE
DE APPR.	<i>M</i>	WEARPLATE	NTS
DATE	17.02.14	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

D4918-7 WEARPLATE
MAKE FROM D4918-7F

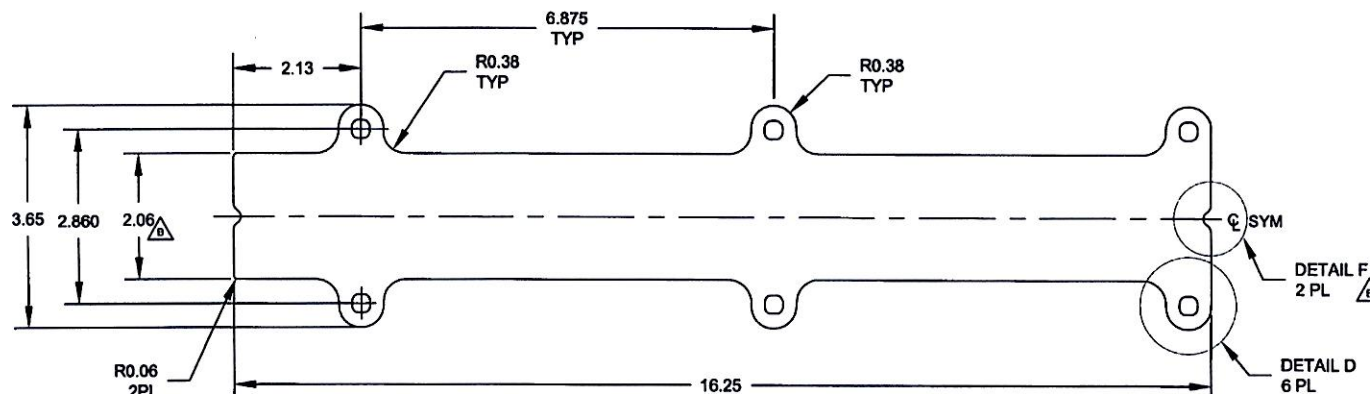
SECTION E-E
SCALE 2X



DETAIL F
SCALE 2X



DETAIL D
SCALE 2X



D4918-7F WEARPLATE
FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED PER MIL-S-5059 OR AMS 5513
OR AMS 5524 OR ASTM A240 OR ASME SA240
16 GAUGE (0.063 THICK)
(REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.66 lbs

RELEASED
2017-04-12

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	SAD	EUGENE, OR	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4918	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
DATE	17.02.14	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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